

# SAFETY INSTRUCTIONS

These safety instructions are to be kept on file or reference for the lifetime of the hook.

## WELD-ON BUCKET HOOK

### WBH



### IMPORTANT SAFETY INFORMATION READ, UNDERSTAND AND FOLLOW

#### ASSEMBLY INSTRUCTION

- Before welding, the welding surface (hook and support structure) must have no distortion, be clean and free of rust, grease, paint, lubricants, etc. The surface material must be suitable for welding.
- Hook material is Gr.80 35CrMo
- The support structure that the hook is attached to must be of suitable size and adequate quality to allow for proper attachment to support anticipated loads. A QUALIFIED PERSON MUST DETERMINE IF THE SUPPORT STRUCTURE IS SUITABLE AND ADAQUATE FOR EACH APPLICATION THE HOOK IS USED IN.
- The original equipment manufacturer must approve use/attachment of weld on hook to their product or machinery.

#### WELDING INSTRUCTION:

**When welding the hook to carbon or low alloy steels <40% carbon, use the following recommendations. For other grades of steel, a weld procedure must be developed by a qualified person.**

- Welding is to be performed by a qualified welder using procedures in accordance with American Welding Society (AWS), ASME and or ISO 9606-1

- Ensure there is a 1/8" maximum gap or less between support and hook base. If measurement in any area exceeds 1/8" a qualified person will need to determine modifications to the support structure to reduce gap.
- Welding electrodes to be in accordance with AWS A5.4 E-312-16 or table below:

NFA 81-343 E-29-R26	ISO 358 E-29-R26
AWS (5.4) E 312-16	DIN 8556 E30-09R26
DIN 8556W Nr. 1.4337	

- The welding process, determined by a qualified person, must not be interrupted for such a time the welding plate loses the welding temperature. Proper pre heat temperature will slow the cooling rate for better weld integrity. This will be dependent on ambient temperature and base metal thickness. Always reference the welding specifications referenced in this manual or a qualified person to determine proper welding procedures.
- Fasten hook provisionally in desired position determined by a qualified person.
- Weld fillet continuous at the base. Fillet size should be minimum size corresponding with WLL of hook as shown **TABLE 1**
- Welding should be applied completely around base in a minimum of two passes to provide adequate root penetration at the base of the weld on hook. Weld all seams at the same temperature.
- Do not rapidly cool the weld.
- Before painting, carefully examine the weld. No inclusions, undercuts, cracks, pitting are allowed. If necessary, use a suitable NDE method, such as dye penetrant or Mag Particle to verify.
- It is recommended the weld on hook assembly be proof tested before use.

<b>TABLE 1</b>			
<b>WLL TON</b>	<b>PART #</b>	<b>MIN PLATE THICKENSS (in.)</b>	<b>MIN WELDING SEAM/FILLET SIZE ALL AROUND (in.)</b>
1	WBH01C	3/16	3/16
2	WBH02C	1/4	1/4
3	WBH03C	5/16	5/16
5	WBH05C	3/8	3/8
8	WBH08C	1/2	1/2
10	WBH10C	1/2	1/2
16	WBH16C	5/8	5/8
20	WBH20C	5/8	5/8

### **REGULAR PERIODIC INSPECTION**

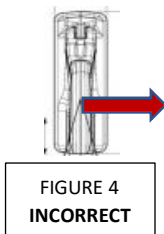
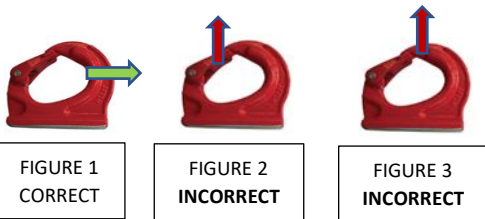
A visual periodic inspection of the weld on hook shall be performed at regular time intervals to ensure proper integrity to remain in service. Use a NDE method if necessary. Ref ASME B30.10

### **INSPECTION CRITERIA BEFORE EACH USE:**

- Ensure there are no cracks, nicks, excessive wear, gouges or any deformation.
- Evidence of corrosion (pitting)
- Cracks or damage to the weld seam
- Complete, readable Working load limit.
- Ensure latch is working properly and bridges throat opening. Use only OEM parts.
- Ensure saddle of hook has no burrs or flashing, sharp edges that can cut into synthetic slings or attachments.
- Ref ANSI/ASME B30.10 “hooks” for more information

### **PROPER USE:**

- Load should be centered in the base of the hook, along the main axis, parallel to the support surface. FIGURE 1
- Hook must always support the load, never by the latch. FIGURE 2
- Never tip load or side load. FIGURE 3
- Never side load FIGURE 4
- Never apply more force than the hooks’ assigned WLL
- See ANSI/ASME B30.10 “hooks” for more information



<b>WARNING</b>
• <b>READ AND UNDERSTAND AND FOLLOW ALL INSTRUCTIONS IN THIS MANUAL.</b>
• <b>REF ASME B30.9, B30.10 AND OSHA 1910.184 BEFORE USE.</b>
• <b>DO NOT LIFT PEOPLE OR LOADS OVER PEOPLE WITH WELD ON HOOK AND ATTACHMENTS</b>
• <b>ALWAYS INSPECT HOOK PRIOR TO USE.</b>
• <b>NEVER LIFT ANY LOAD OR APPLY FORCE ABOVE HOOKS WORKING LOAD LIMIT.</b>
• <b>INCORRECT USE CAN CAUSE LOADS TO DISENGAGE AND FALL CAUSING SERIOUS INJURY OR DEATH.</b>
• <b>ALWAYS ENSURE HOOK IS PROPERLY SUPPORTING THE LOAD BEFORE LIFTING</b>
• <b>NEVER LIFT AN UNBALANCED LOAD</b>
• <b>ENSURE USER IS PROPERLY TRAINED IN THE USE OF THIS PRODUCT PRIOR TO USE.</b>



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